

Date: Wednesday, 1/9/2008 3:42:10 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SPACER BUSHING		
Job Number	36697					
Estimate Number	10826					
P.O. Number	:		Part Number	:	D23273	
This Issue	: 1/9/2008	S.O. No. :	Drawing Number	:	D2327 REV D	
Prsht Rev.	: NC		Project Number	:	N/A	
First Issue	: / /	Type : MACHINED PARTS	Drawing Revision	:	D	
Previous Run	: 36479		Material	:		
Written By	:	10	Due Date	:	1/21/2008	Qty: 50 Um: Each
Checked & Approved By	<u>10/08/01/09</u>					
Comment	Est. F 05.11.02 Removed 303 SS KJ/EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304R0375	304 SS ROUND BAR	
		Comment: Qty.: 0.1641 f(s)/Unit Total : 8.2058 f(s) Inventory Material: AISI 304 Round Bar Ø0.375" (M304R0.375)	Batch: <u>M1068C0</u> <u>H.A 08/01/19</u>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Turn per Folio FA232 and Dwg D2327 Deburr	<u>H.A fmz 08/01/19</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>H.A fmz 08/01/19</u>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>RG 0801.20</u> <u>50</u>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>U 08.01.21</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/9/2008 3:42:11 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 36697

Part Number: D23273

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.21

Job Completion



U 08.01.30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36697
Description: Spacer Bushing	Part Number:	D2327-3
Inspection Dwg: D2327	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

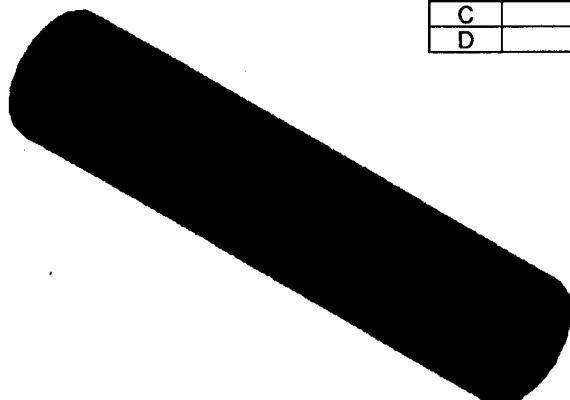
Measured by:	<u>K.A / gwy</u>	Audited by:	<u>RJ</u>	Prototype Approval:	N/A
Date:	08/01/19	Date:	08/01/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	E

DART

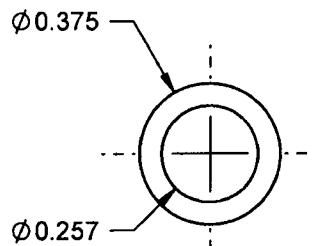
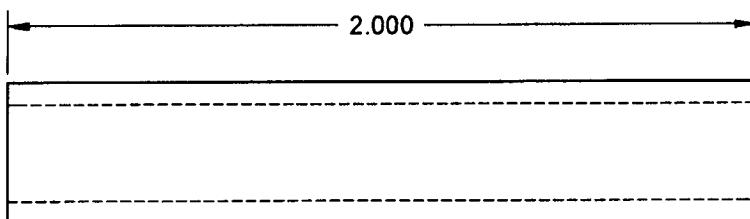
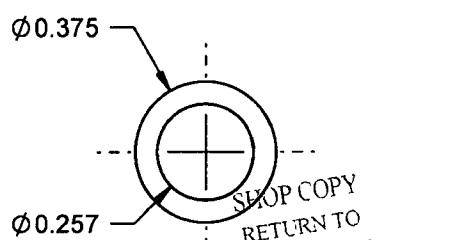
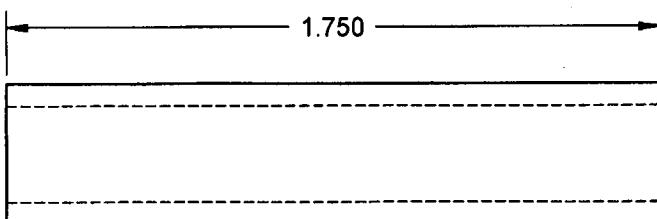
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>LE</i>	APPROVED <i>CH</i>	DRAWING NO. D2327
DATE 06.10.12	TITLE SPACER BUSHING	REV. D SHEET 1 OF 1 SCALE 2:1

REV	DATE	DESCRIPTION
A	94.12.17	NEW ISSUE
B	95.12.06	LENGTH CHANGE
C	03.05.13	303 SS SPEC ADDED
D	06.10.12	REMOVE 303 SS MATERIAL



RELEASED

06.11.14

**D2327-1 SPACER BUSHING****D2327-3 SPACER BUSHING****NOTES:**

- 1) MATERIAL: AISI 304/316 SS, Ø 0.375, 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
3669

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